

ABSTRACT OF THE DISCLOSURE

A method for inserting blanks to be threaded in automatic rotary rolling machines, in which the step for inserting parts to be machined in the working position occurs at an adjustable, optimized rate, so that the portions of the outer surface of the roller tool affected by contact with the parts that have been inserted vary continuously at each turn of the spindle. This provides a significant reduction in surface wear of the roller, extending its useful life. The invention also relates to an automatic rotary rolling machine.